





Date: Monday, 28/07/2008 3:38:57 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG T-HANDLE ASSEMBLY

Job Number: 40770

Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Lot E*

*MF 08-08-26*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/08/27*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 08-08-26*

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Drawing Name: LONG T-HANDLE ASSEMBLY

Job Number: 40770

Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/31 (3)

7.0

PB674300189

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Clevis  
batch: 323986

08-08-12 3

8.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
SPRING SLOTTED PIN  
batch: M11850

08-08-12 3

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- line drill -89 and -87 using existing pilot hole of -87 as per dwg  
2- install spring pin

08-08-12 3

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/12 (x3)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30  
323  
4:00

M. 08/08/12

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-13

(x3)

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## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONG T-HANDLE ASSEMBLY
Job Number	: 40770		
Estimate Number	: 13522		
P.O. Number	:	Part Number	: PB674300151
This Issue	: 28/07/2008 S.O. No. :	Drawing Number	: B6743001 P.13
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 04/08/2008 Qty: <u>3</u> Um: Each
Checked & Approved By	: <u>MC 08-07-28</u>		
Comment	: Est Rev:A 08-07-25 new issue DD verified by:ec		

## Additional Product

*See attachment*

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300187	Tube Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Arm

batch: M1079504 *pulled mat.*

*pk 08-07-29 3*

2.0	PB674300191	Tube Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Handle

batch: M1079504 *18747 pulled mat*

*pk 08-07-29 3*

3.0	PB674300193	Tube End Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Tube End Cap

batch: 40074

*pk 08-07-29 3*

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- drill #40 hole in center of -91 before welding -93 caps, to let air out

2- weld -93 to -91 as per dwg

3- grind weld flush

4- assemble -87 under the pilot hole in -91 and weld as per dwg

*pk 08-07-29 3*

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*5086731 (A3)*